

Work Order ID 101834-2

101834

Page 1

Item ID: D2230-1

Revision ID:

Item Name: Lug

Start Date: 5/13/13

Start Qty: 320.00

Required Date: 5/31/13

Req'd Qty: 320.00

Reference:

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

CL

Date: 13/05/14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2230

Rev G

100

0.00

100

BAND SAW

Bandsaw

Jeaspa Bandsaw

Memo

Cut D2423 extrusion to 0.82"

Batch:

cut @ metec

0.00

CL 13/05/14 320

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

Memo

1-Machine per folio FA927

DWG REV:

FOLIO REV:

(Check for crack while loading into the machine.)

2- deburr rough edges

0.00

CL 13/05/14 320

issue P/O to metec

machine is per day D2230 REV.G

Work Order ID 101834

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Page 2

Item ID: D2230-1

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug

Start Date: 5/13/13 Start Qty: 320.00

320

Cust Item ID:

Required Date: 5/31/13 Req'd Qty: 320.00

320

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130 *rec'd*
120
QC
Quality Control

~~QC2 - Inspect parts off machine FAI/FAIB~~

0.00

Memo

0.00

*rec'd + inspect
attached e.g. to w/c*

130
130
QC
Quality Control

QC - Inspect parts - second check

0.00

Memo

0.00

*215
BS IS*

200

140
140
HandFinish
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

200 7/13.5 1/6

*4
17
6
100*

Work Order ID 101834

101834

Page 3

May-13-13 1:15:15 PM

Item ID: D2230-1

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug

Start Date: 5/13/13 Start Qty: 320.00

320

Cust Item ID:

Required Date: 5/31/13 Req'd Qty: 320.00

320

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Quality Control

Memo

0.00

200 X Ø m-f 13/05/23

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

160

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

170

QC3- Inspect Part Finish

0.00

170

QC

Quality Control

Memo

0.00

200 X Ø m-f 13/05/23

200. Ø



13-05-29

m125620

2-15
3200 F
2-45

Work Order ID 101834

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Page 4

Item ID: D2230-1

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Lug

Start Date: 5/13/13

Start Qty: 320.00

320

Cust Item ID:

Required Date: 5/31/13

Req'd Qty: 320.00

320

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Identify as per dwg & Stock Location:

0.00

180

Packaging

Memo

ST409

0.00

Packaging

4/3/6/3

200

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

13/6/4

PLB-05-3

Picklist Print

May-13-13 1:15:15 PM

Page 1

Work Order ID: 101834
Parent Item: D2230-1
Parent Item Name: Lug

Start Date: 5/13/13
Start Qty: 320.00

Required Date: 5/31/13
Required Qty: 320.00

Comments: IPP D00.11.01 Added inspection level 8, and removed P/O for powder coatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-1P LUG		Purchased	No				Each	0.0000		320		4/3/13	(200)
D2423 Lug Extrusion		Manufactured	No			110	f	588.7400	0.0683	23.006304		05/13/05/14	

Location

Loc Qty

Loc Code

MAT006

383

43722

161.5

87953

221.5

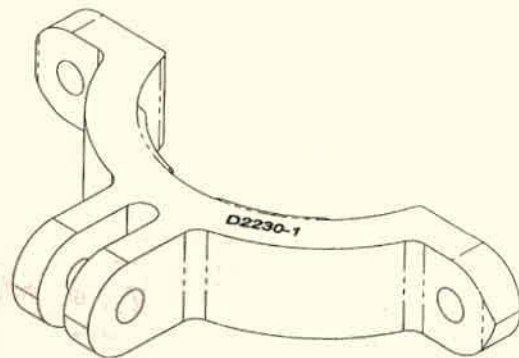
Metec

205.74

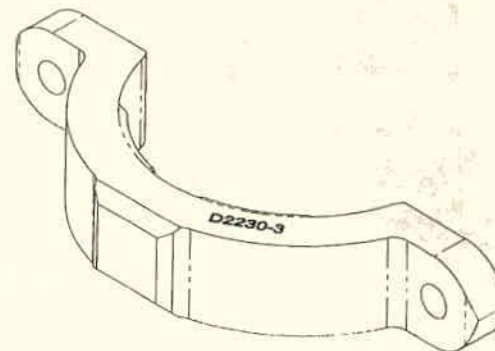
93551

205.74

23.006



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

CL 13/05/14
W10: 101834

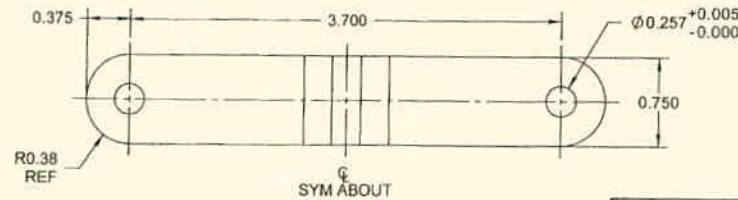
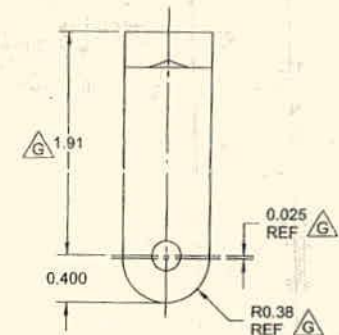
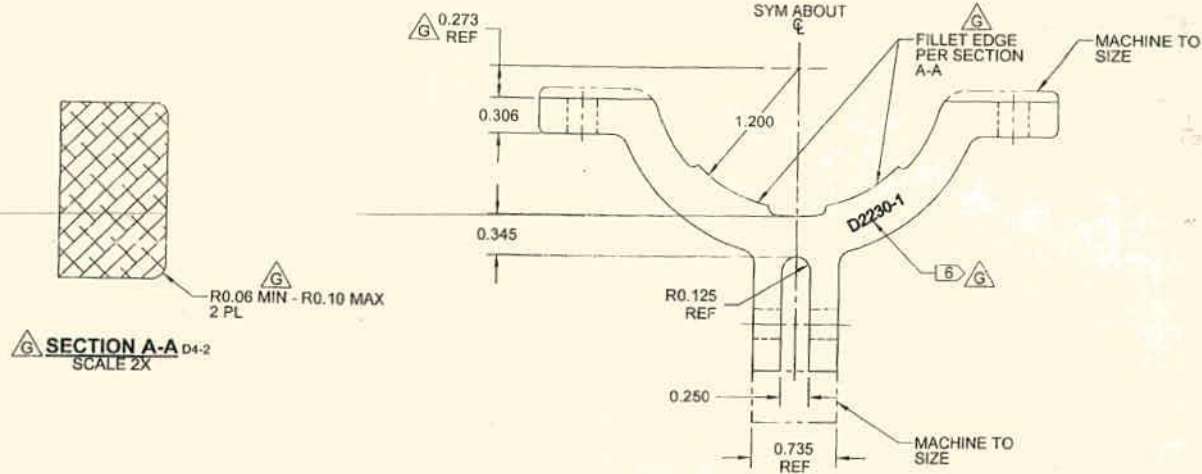
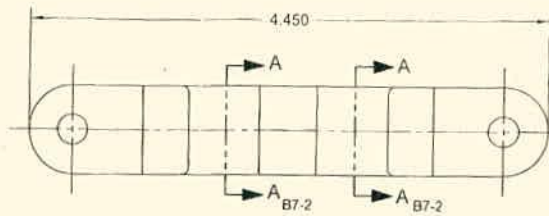
RELEASED
09/01/16



NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1 200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THE INFORMATION IS PROVIDED AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER COMMERCIAL OR INDUSTRIAL PURPOSE WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D2230-1 MOUNTING LUG

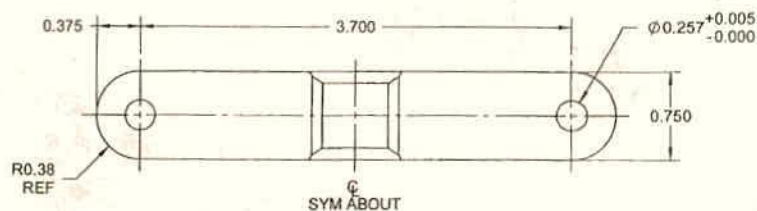
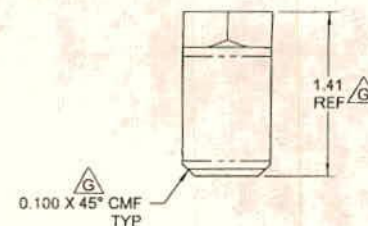
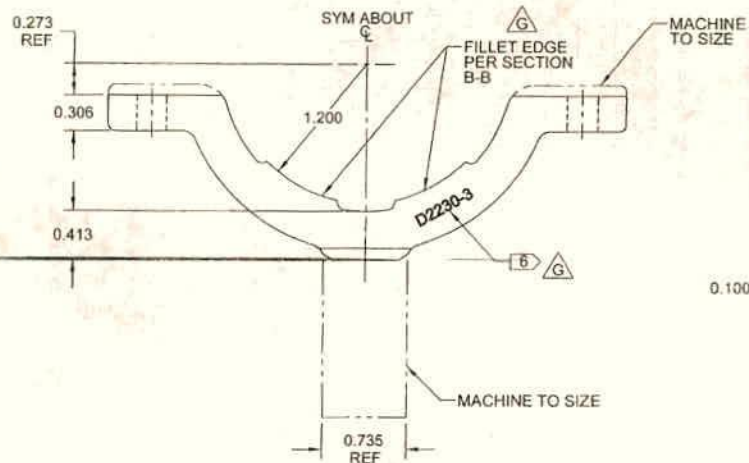
RELEASED
09/06/75 M

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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SECTION B-B D4-3
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

RELEASED
09/06/2014

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 19036
Date: May 13, 2013
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 19868	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date: May 15, 2013

Description		Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-3	Mounting Lug as per drawing D2230 REV.G , B101450	Each	300	200	100
D2230-3	Mounting Lug as per drawing D2230 REV.G, B101495	Each	300		300
D2230-1 B101834	Mounting Lug as per drawing D2230-1 REV.G,	Each	320	200	120
D3235-1 B101559	Mounting Lug as per drawing D3235-1 REV.A,	Each	200	100	100
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.					
Received by _____		Thank you for your order!			



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
200	D2230-3	Lug	PO 19868
200	D2230-1	Lug	PO 19868
100	D3235-1	Lug	PO 19868

MATERIAL: supplied by DART B93551

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, May 15, 2013